

Work Order ID 74024

Tuesday, September 20, 2011 1:00:17 PM



Page 1

Item ID:	D3213-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Door Assembly					
Start Date:	9/20/2011	Start Qty:	4.00	Cust Item ID:		
Required Date:	10/3/2011	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	11-09-20	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3213	B								

100
 Small Fab 0.00
 Small Fab Memo 0.00
 Small Fab 1-Assemble as per Dwg D3213 Transfer drill hinge using DT8470 & DT9520
 Identify as D3213-041

8/11/10/27 (4)

110
 QC5- Inspect part completeness to step on W/O 0.00
 QC Memo 0.00
 Quality Control

(74)

120
 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00
 Powdercoat Memo 2'-45 0.00
 Powder Coating START TIME: 3200F FINISH TIME: 375

4X8 M 11/10/27

M 117338

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3213-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Assembly

Start Date: 9/20/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/3/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Packaging	Identify as per dwg & Stock Location: <u>211</u> Memo	0.00 0.00					<u>11/11/11</u>	<u>SP</u>	<u>40</u>
170 QC	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<u>mlu1014</u>	
Packaging									
Quality Control									

mf 11-11-01

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Picklist Print

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Work Order ID: 74024

Parent Item: D3213-041

Parent Item Name: Door Assembly



Start Date: 9/20/2011

Required Date: 10/3/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-17 17:27

Component Item ID / Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-3 Hinge 15.0"		Manufactured	No			100	Each	4.0000	2	8			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST037				4					
					68895			4					
D3213-1 Door Panel		Manufactured	No			100	Each	4.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST232B				4					
					68906			4					
D3213-3 Door Panel		Manufactured	No			100	Each	6.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST232B				6					
					68907			6					
MS20470AD4-6 Rivet, Universal Head		Purchased	No			100	Each	2,704.000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST319				2704					
					117395			32					
					117887			1157					
					118927			1515					

Handwritten notes and signatures:

- Signature: *[Signature]* 11/10/27
- Signature: *[Signature]* 11/10/27
- Signature: *[Signature]* 11/10/27
- Signature: *[Signature]* 11/10/31
- Handwritten: B 74028
- Handwritten: 4
- Handwritten: 4
- Handwritten: 4
- Handwritten: 4

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Parent Item Name: Door Assembly

Start Date: 9/20/2011

Required Date: 10/3/2011

Start Qty: 4.00

Required Qty: 4.00

D2137
Decal - No Step

Manufactured No

140 Each 14.0000

Location

Loc Qty

Loc Code

ST006

14

72053

14

D2419
Handle

Manufactured No

140 Each 4.0000

Location

Loc Qty

Loc Code

GA

4

69732

4

D2462
Seal

Manufactured No

140 f 455.8674

Location

Loc Qty

Loc Code

ST404

455.8674

48530

455.8674

D2728-1
Dart Logo label

Manufactured No

140 Each 0.0000

MS20470AD4-4
Rivet, Universal Head

Purchased No

140 Each 3,390.000

Location

Loc Qty

Loc Code

ST139

78

117423

78

ST319

3312

116188

136

116391

66

118614

3110

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Shop Packet Print

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Parent Item Name: Door Assembly

Start Date: 9/20/2011

Required Date: 10/3/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149DN632J

Purchased

No

140

Each

892.0000

1

4



Washer



GS 11/10/31
4

Location

Loc Qty

Loc Code

ST297

892

118428

892

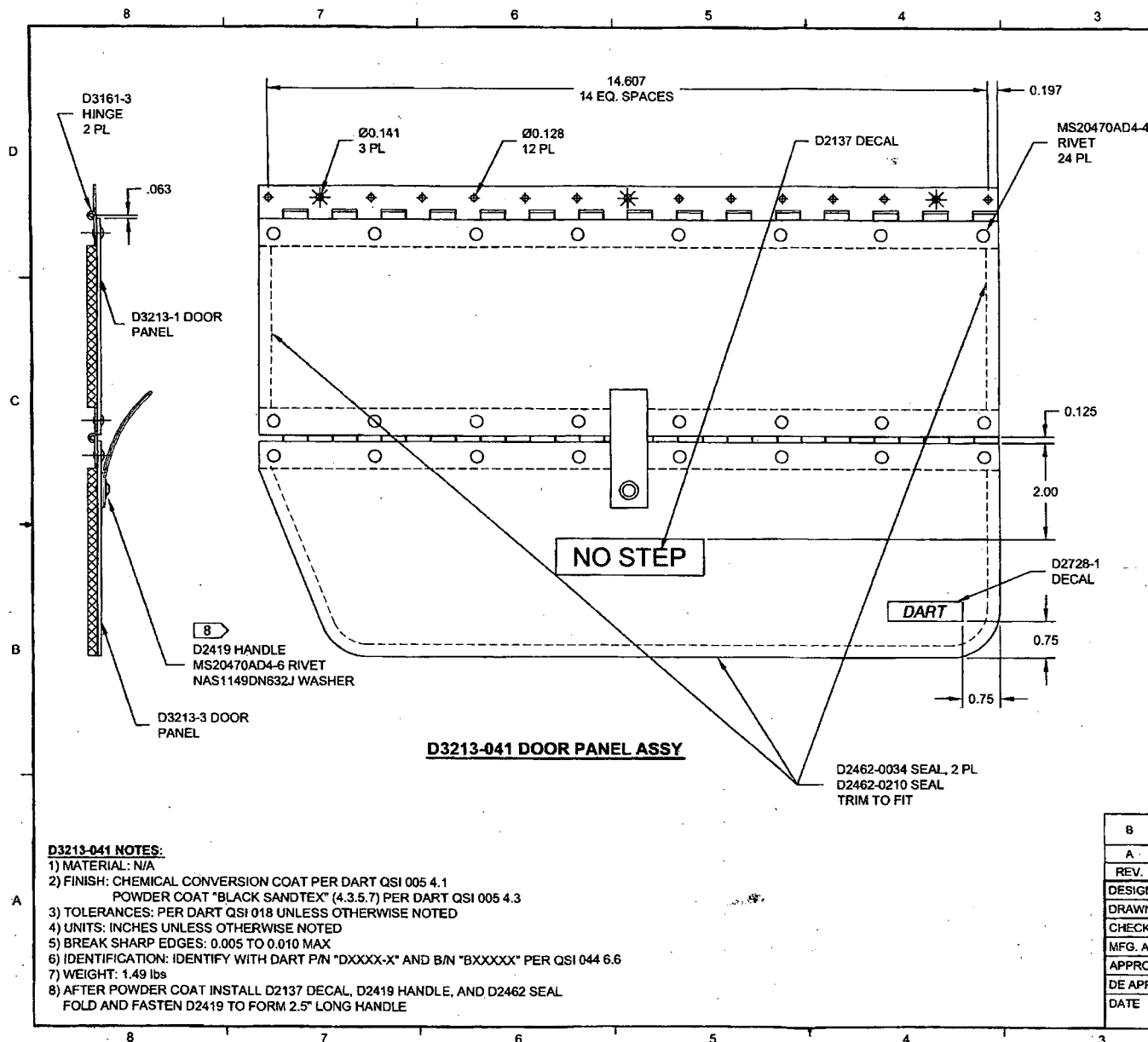
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QTY	PART NUMBER	DESCRIPTION
-041		
X	D3213-041	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0034	SEAL
1	D2462-0210	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
2	D3161-3	HINGE
1	D3213-1	DOOR PANEL
1	D3213-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
24	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74024

11-09-20
RELEASED
2011-06-14

B	FORMAT TO CURRENT STD; ADD D3213-041B REASON: PAR11-109.	MB	11.06.06
A	NEW ISSUE	CP	03.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.06		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3213	REV. B
TITLE DOOR ASSEMBLY	SHEET 1 OF 4
SCALE NTS	

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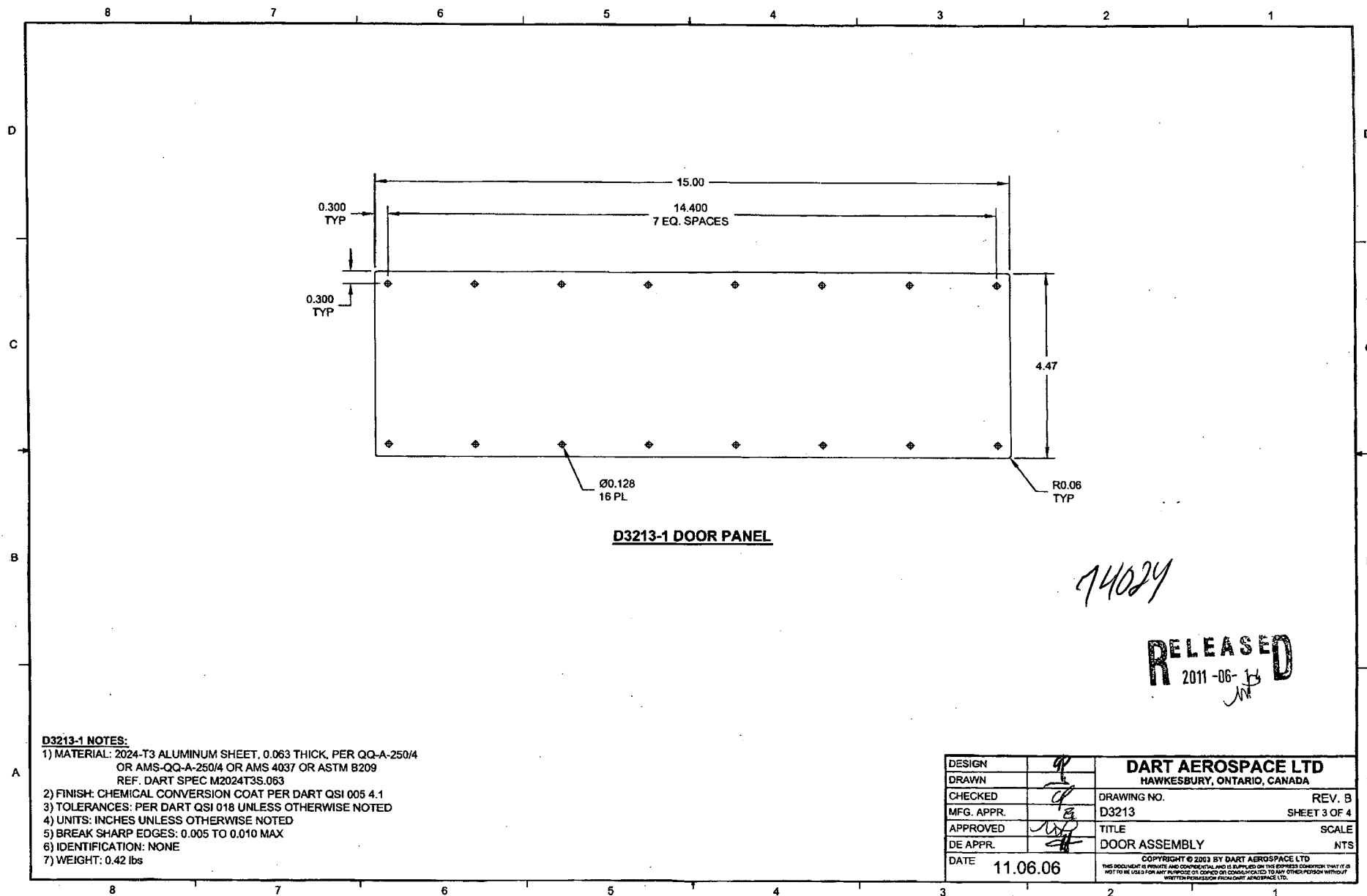
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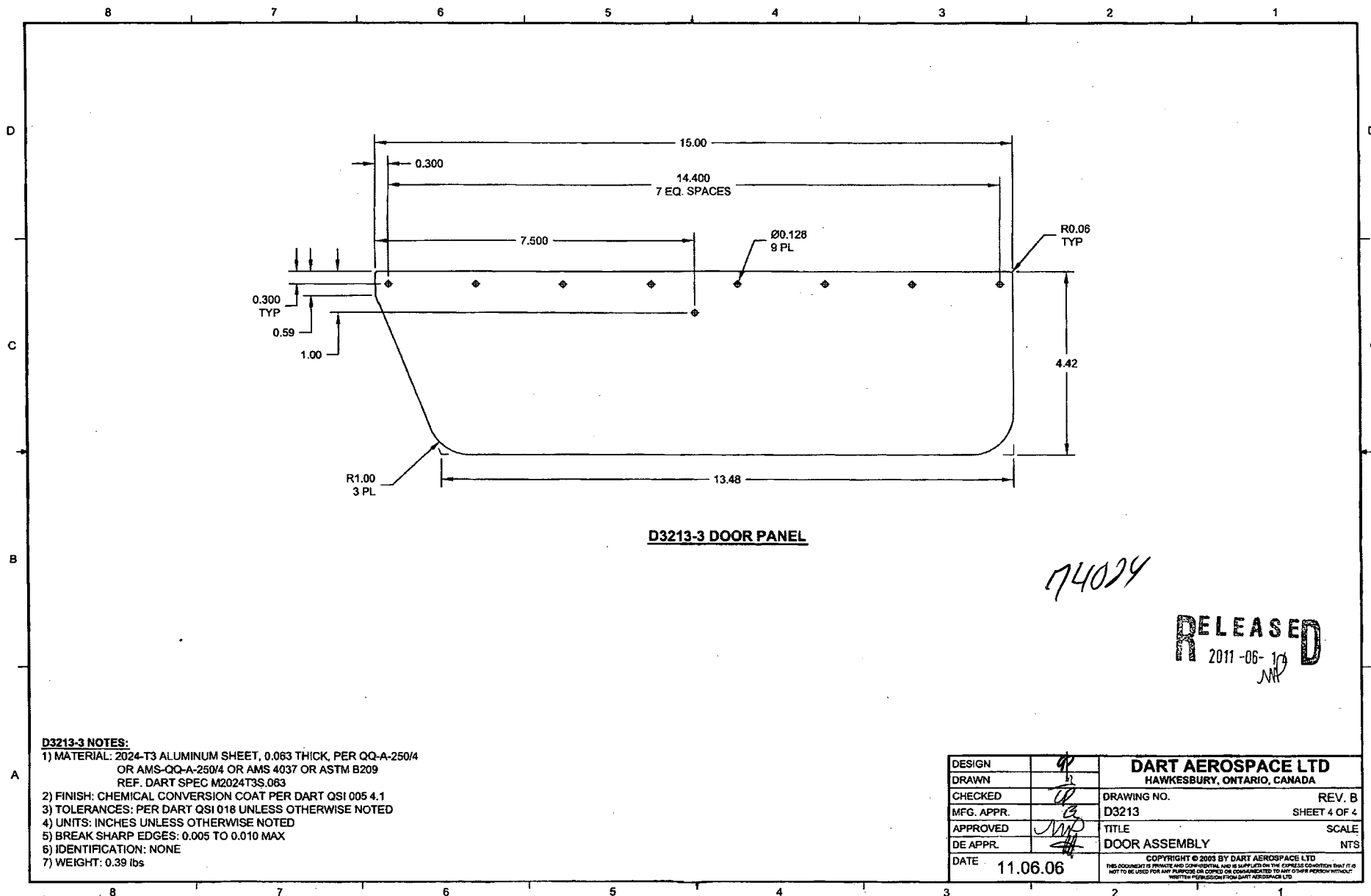
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